

32

Date: Thursday, 7/19/2007 2:15:12 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEAR SHOE KIT
Job Number : 33617	
Estimate Number : 12939	
P.O. Number : <i>N/A</i>	Part Number : DSI9372011
This Issue : 7/19/2007 S.O. No. : <i>N/A</i>	Drawing Number : DSI9372 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 33404	Material : <i>N/A</i>
Written By : _____	Due Date : 8/10/2007 Qty: 4 Um: Each
Checked & Approved By : <i>07.07.19</i>	
Comment : EsRev:A New Issue 07-07-09 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Photocopy bluefile & type labels per PPPDSI9372-011 CHG001

07.07.30 *JS*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0	D35645	WEARSHOE
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 WEARSHOE
 Batch: *32738* ✓ *SP*

4.0	D35649	WEARSHOE
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 WEARSHOE
 Batch: *33457* ✓ *0.7/7/26*

5.0	D356411	WEARSHOE
-----	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 WEARSHOE
 Batch: *33455* ✓ *7/7/26* *SG*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

Date: Thursday, 7/19/2007 2:15:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR SHOE KIT

Job Number: 33617

Part Number: DSI9372011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

* WEARSHOE

Batch: 31398

✓

sq

7.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

GASKET

Batch: 32734

✓

sq

8.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

GASKET

Batch: 31421

33483

✓

sq

9.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

GASKET

Batch: 33260

3

①

21399

31348

sq

10.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total : 200.0000 Each(s)

BOLT

Batch: 1105052

OKY

u of 0726

sq

11.0

AN960C10L

washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 200.0000 Each(s)

washer

Batch: 1104885

208

sq

sub

12.0

ALS41032130

Insert



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Insert

Batch: 1103495

7/7/26 sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 27/07/13

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:15:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR SHOE KIT

Job Number: 33617

Part Number: DSI9372011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

U 07-07-27

(4) 07/17/30 (4)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP DSI9372-011

Location: _____

PPP Rev: _____

DART

07/17/30

(4)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/07/30

Job Completion



U 07-07-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9372	REV. A SHEET 1 OF 2
DATE 07.03.19		TITLE STAINLESS STEEL WEARSHOE KITS	SCALE NTS
A	07.03.19	NEW ISSUE	

DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. D OR EARLIER AND
INSTALLATION INSTRUCTIONS D204-635 REV. D OR EARLIER**

REF. CANADIAN STC: SH96-88 ISSUE 3

REF. FAA STC: SR00563NY

For customers with D205-634-011 skidtubes at CHG 004 or earlier and D205-634-015 skidtubes at CHG 003 or earlier who would like to upgrade to stainless steel wearshoes, the DSI 9372-011 wearshoe kit can be obtained from Dart

or

For customers with D204-635-011 skidtubes at CHG 004 or earlier who would like to upgrade to stainless steel wearshoes, the DSI 9372-013 wearshoe kit can be obtained from Dart

QTY -011	QTY -013	Part Number	Description
X		DSI 9372-011	WEARSHOE KIT (D205-634-011/-015 SKIDTUBES)
	X	DSI 9372-013	WEARSHOE KIT (D204-635-011 SKIDTUBES)
1		D3564-5	WEARSHOE (REPLACES D2577-5)
	1	D3564-7	WEARSHOE (REPLACES D2577-7)
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-13	*WEARSHOE
2	2	D3566-1	GASKET
1		D3566-5	GASKET
	1	D3566-7	GASKET
1	1	D3566-13	*GASKET
50	44	AN3C4A	BOLT
50	44	AN960C10L	WASHER
6	6	ALS4-1032-130	*INSERT

* OPTIONAL TO INSTALL

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WITHOUT NOTICE
WORK ORDER
NO. **33617**

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.03.19
CERT. NO.: SH96-88
ISSUE NO.: 3

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DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9372	REV. A SHEET 2 OF 2
DATE 07.03.19	TITLE STAINLESS STEEL WEARSHOE KITS		SCALE NTS

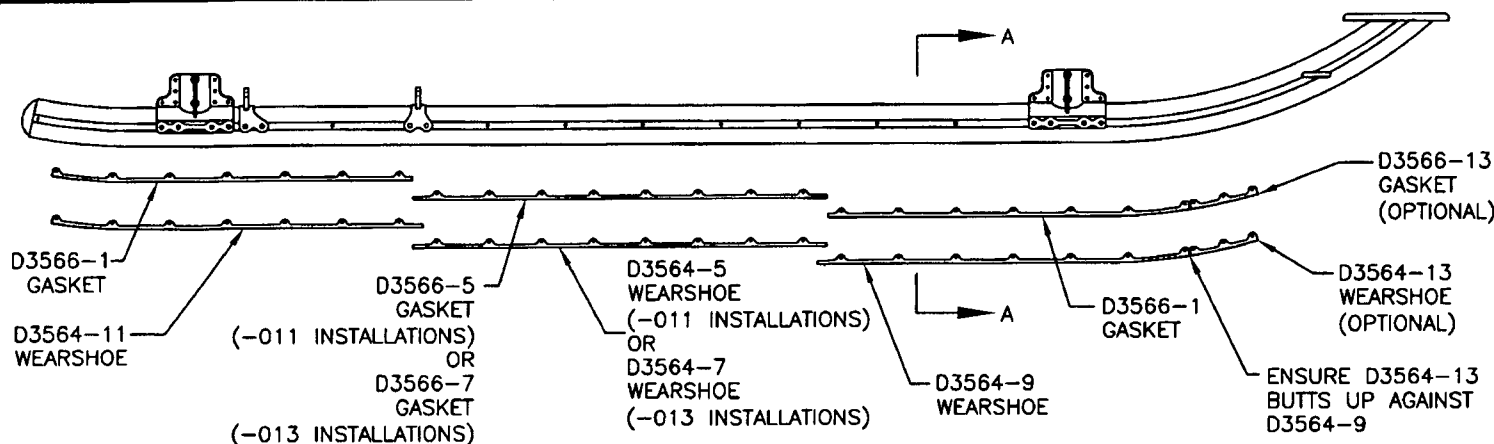
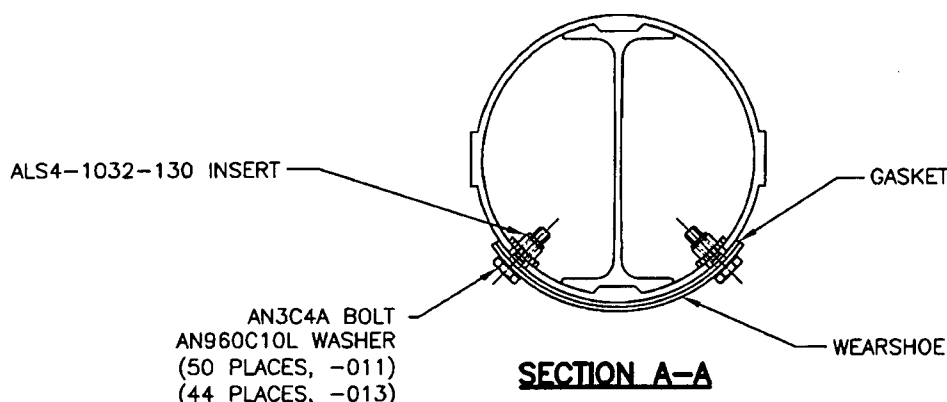


FIGURE 1: DSI9372-011/-013 WEARSHOE KIT INSTALLATION
(D205-634-011 SKIDTUBE SHOWN, D204-635-011 SIMILIAR)



DSI 9372-011/-013 Wearshoe Kit Installation Procedure

- 1) Remove skidtube from aircraft per Section 32.1 of ICA-D205-634 or ICA-D204-635.
- 2) Remove existing D2577-1/-3/-5/-7 wearshoes by removing AN3 hardware. Begin wearshoe removal from the fwd end of the skidtube towards the aft end.
Note: Removing the wearshoes may require breaking a layer of sealant between the wearplates and the skidtube.
- 3) Clean residual sealant off the bottom of the skidtube. Check for corrosion and mechanical damage in accordance with Chapter 5 of ICA-D205-634 or ICA-D204-635 and repair as required.
- 4) **Installation of D3564-13 Wearshoe and D3566-13 Gasket (optional)**
Temporarily install the D3564-9 wearshoe complete with D3566-1 gasket at the fwd end of the skidtube as shown in Figure 1. Temporarily clamp the D3564-13 wearshoe and D3566-13 gasket ensuring that the wearshoe butts up against the D3564-9 wearshoe. Using the D3564-13 wearshoe as a template, drill $\varnothing 0.125$ holes in the center of the wearshoe oboards (6 places). Remove wearshoes and open the $\varnothing 0.125$ holes to $\varnothing 0.297$. Deburr. Touch up holes with chemical film material (Alodine 1200/1201) per MIL-C-5541 and one coat of MIL-P-85582 or MIL-P-23377 primer. Install ALS4-1032-130 inserts.
- 5) Install D3564-5/-7/-9/-11/-13 wearshoes complete with D3566-1/-5/-7/-13 gaskets using AN3C bolts beginning from the aft end of the skidtube and install towards the fwd end of the skidtube as shown in Figure 1. Seal all bolts with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing. Torque bolts to 15-25 in-lbs (1.7-2.8 N-m).
- 6) Re-install skidtube on aircraft per Section 32.2 of ICA-D205-634 or ICA-D204-635.

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WITHOUT NOTICE
WORK ORDER
NO. 33617

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.03.19
CERT. NO.: SH96-88
ISSUE NO.: 3

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